



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 196295



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/12/19

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		7/12/19	0.00	0.65	Skidtubes - Bend		MGC
120	Skidtubes - 2 - B4B	1 pcs		7/12/19	0.00	2.89	Skidtubes - 1 - B4B		DD
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		7/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Skidtubes - 3 - B4B	1 pcs		7/12/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		



Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S199594



Part: D205-634-041

Job No: 196295

Serial No/Batch: S199594

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3 of 3 FAA-TC SR005631

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					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BL
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
150 QC 10	1 pcs	7/12/19	0.00 0.00		QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
160 QC 5	1 pcs	7/12/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	7/12/19	0.00 1.31		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 -	

DAS
68
9-89

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AUG 28 2019

★ AUG 29 2019

				B4B		
				Handfinish - 1 - 22 - B4B		
180 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/12/19	0.00 0.34	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
190 QC 3	1 pcs	7/12/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
200 Handfinish - 4-1-Assembly- B4B	1 pcs	7/12/19	0.00 1.00	Handfinish - 4 - 1 - B4B		
				Handfinish - 4 - 10 - B4B		
				Handfinish - 4 - 11 - B4B		
				Handfinish - 4 - 12 - B4B		
				Handfinish - 4 - 13 - B4B		
				Handfinish - 4 - 14 - B4B		
				Handfinish - 4 - 15 - B4B		
				Handfinish - 4 - 2 - B4B		
				Handfinish - 4 - 3 - B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
210 QC 5	1 pcs	7/12/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		

DAS
15
9-89

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
220	Packaging 3-1 - Stock - B4B	1	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS SEP 06 2019 40 9-89
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
225	DC - 1 - B4B	1	7/12/19	0.00 0.00	DC - 1 - B4B	DAS 21 9-89
	pcs				DC - 2 - B4B	SEP 10 2019
230	QC 21 - FG	1	7/12/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-89
	pcs				QC 21 - FG - 70	SEP 10 2019
					QC 21 - FG - 53	

Part Op 110 - Skid tubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# in aft end of tube

120 - Skid tubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skid tubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME:

OVEN TEMPERATURE:

FINISH TIME: _____

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on Insert holes before installing wearplates A/R Sikaflex-291 5171312 Sikaflex expire date: 14-12-9 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5121312 Sikaflex expire date: 14-12-9 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: _____

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	5198058
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	5154382
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5190021
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149159
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5209364
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5196140
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173292
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5126189
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196397
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196227
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201529
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5201653
NAS1149C0332R	Washer	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5193131
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178379

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	5	0
140-Skidtubes - 3 - B4B	D2576-3	1	43	0
	D4202-1	20	769	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	764	0
	AN3-5A	2	176	0
	AN3C4A	50	790	0
	D2594-1	16	186	0
	D2594-3	16	331	0
	D2855	1	47	0
	D3564-11	1	13	0
	D3564-13	1	8	0
	D3564-5	1	9	0
	D3564-9	1	11	0
	NAS1149C0332R	50	2,746	0
	NAS1149D0332J	2	3,280	0

Part Specifications

Specifications could not be found.

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ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2680-041	SKIDTUBE ASSEMBLY
2		X		D2680-045	SKIDTUBE ASSEMBLY
3			X	D2680-047	SKIDTUBE ASSEMBLY
4				D2680-048	SKIDTUBE ASSEMBLY
20	1	1	1	D2680-1-180	EXTRUSION
21			10	D2670	BURNING
22	1	1	1	D2673	STEP
23	4			D2679	SPACER
24	10	10	8	D2684-1	PLUG
25	10	10	8	D2684-3	Q-RING
26	1	1	1	D2688	200 WEB
27	1	1	1	D2684-5	AFT CAP
28	1	1		D2684-5	WEARSHOE
29	1	1		D2684-11	WEARSHOE
30	1	1		D2684-13	WEARSHOE
31	1	1		D2684-1	SPACER
32	20	20	24	D4002-1	WEARPLATE ASSEMBLY
33			1	D4002-043	WEARPLATE ASSEMBLY
34			1	D2681-1	PHD WEARPLATE
35			1	D2681-3	AFT WEARPLATE
80	50	50		AL87-1032-130 or AN57-1032-130 or AN54-1032-130 or HELS-1032-130	INSERT
81	50	50		AN54A	BOLT
82	2	2	2	AN54A	BOLT
83			8	AN4-55A	BOLT
84	50	50		NAS11480C032R	WASHER (AN880C10L)
85	2	2	2	NAS11480C032J	WASHER (AN880C10L)
86			5	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: NVA
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2680 WEB POWDER COAT (M4140474048) GLOSS WHITE (REF 43.2.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2680-041 = 33.7 lbs
D2680-045 = 45.1 lbs
D2680-047 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2680 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-341 ADHESIVE PER DART QSI 018 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 90 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT6217 & DT6657 ONLY FOR D2680-041-045 TO LOCATE AND DRILL 60.207 HOLES FOR WEARSHOE INSERTS. INSTALL AL87-1032-130 PER SECTIONS B-8 AND F-7 (60 PLACES) AFTER FINISH. INSTALL AN54A BOLT8 AND NAS11480C032R WASHER8 WITH SIKAFLEX-241-291.
- 12) INSERT D2684-1 PLUG CW D2684-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES FOR D2680-041-045 AND 8 PLACES FOR D2680-047-048)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2686 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

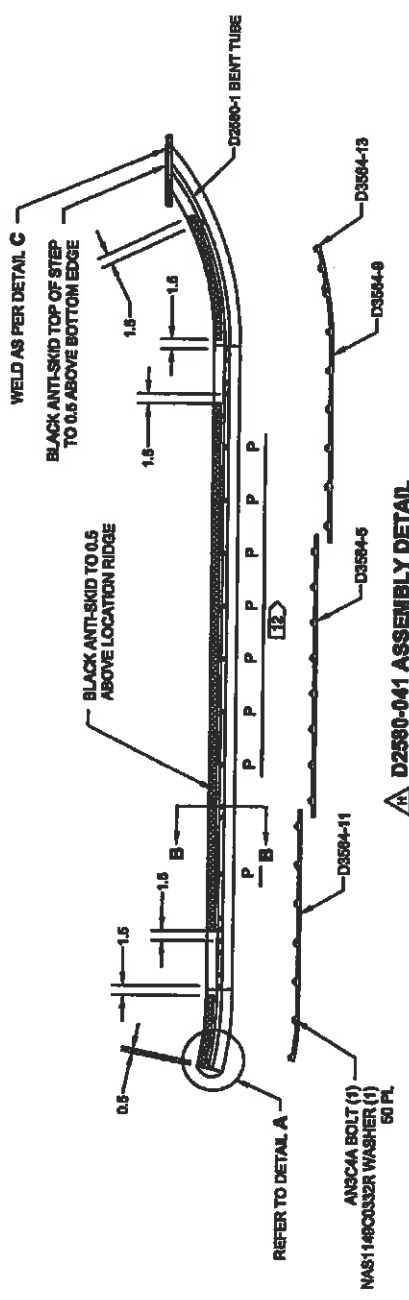
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19629-115
1906-11

H	SHEET: PL DELETE D2686-1A-B-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER DSI 9009	AJS	14.04.09
F	INCORPORATE DEO D2680-E-1 PER PARTS-216	DC	12.06.20
E	ADD D2680-047 (2N CA-7) AND D2680-7 (2N B3-5); INCLUDED DEO D2680-O-1; REFORMATTED DRAWING TO CURRENT STANDARD; DT6217 & DT6657 WAS TO2677-205 (2N CA-1)	RF	11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS, INCLUDE DEO D264 018	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9004 0057	CP	06.06.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	19629-115		
INFO APPR.	D2680		
APPROVED	TITLE		
DE APPR.	2015 SKIDTUBE ASSEMBLY		
DATE	17.06.09		

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2017 JUL 05
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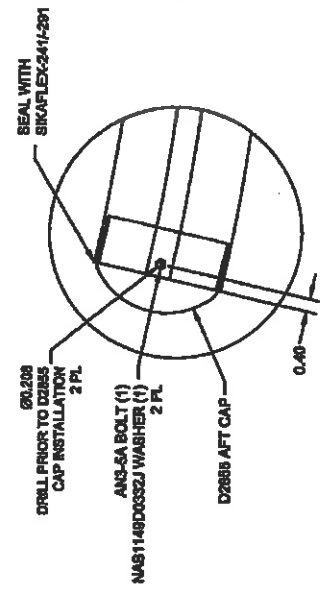
DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	REV. H
DRAWING NO.	SHEET 1 OF 9
D2680	SCALE
TITLE	NTS
2015 SKIDTUBE ASSEMBLY	
DATE	17.06.09

1 2 3 4 5 6 7 8

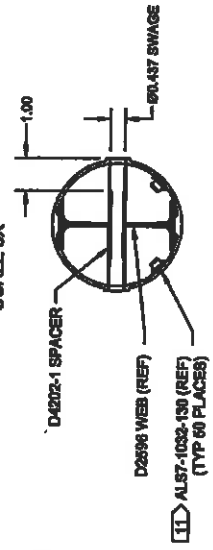


D2580-041 ASSEMBLY DETAIL

DETAIL A
SCALE 5X

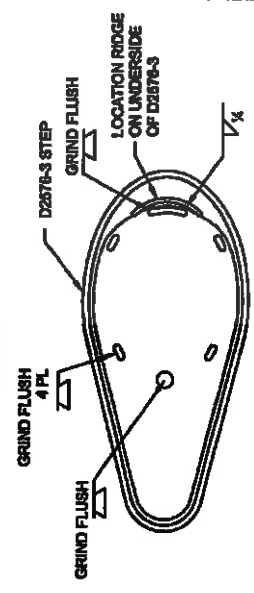


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60.608 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO 60.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X

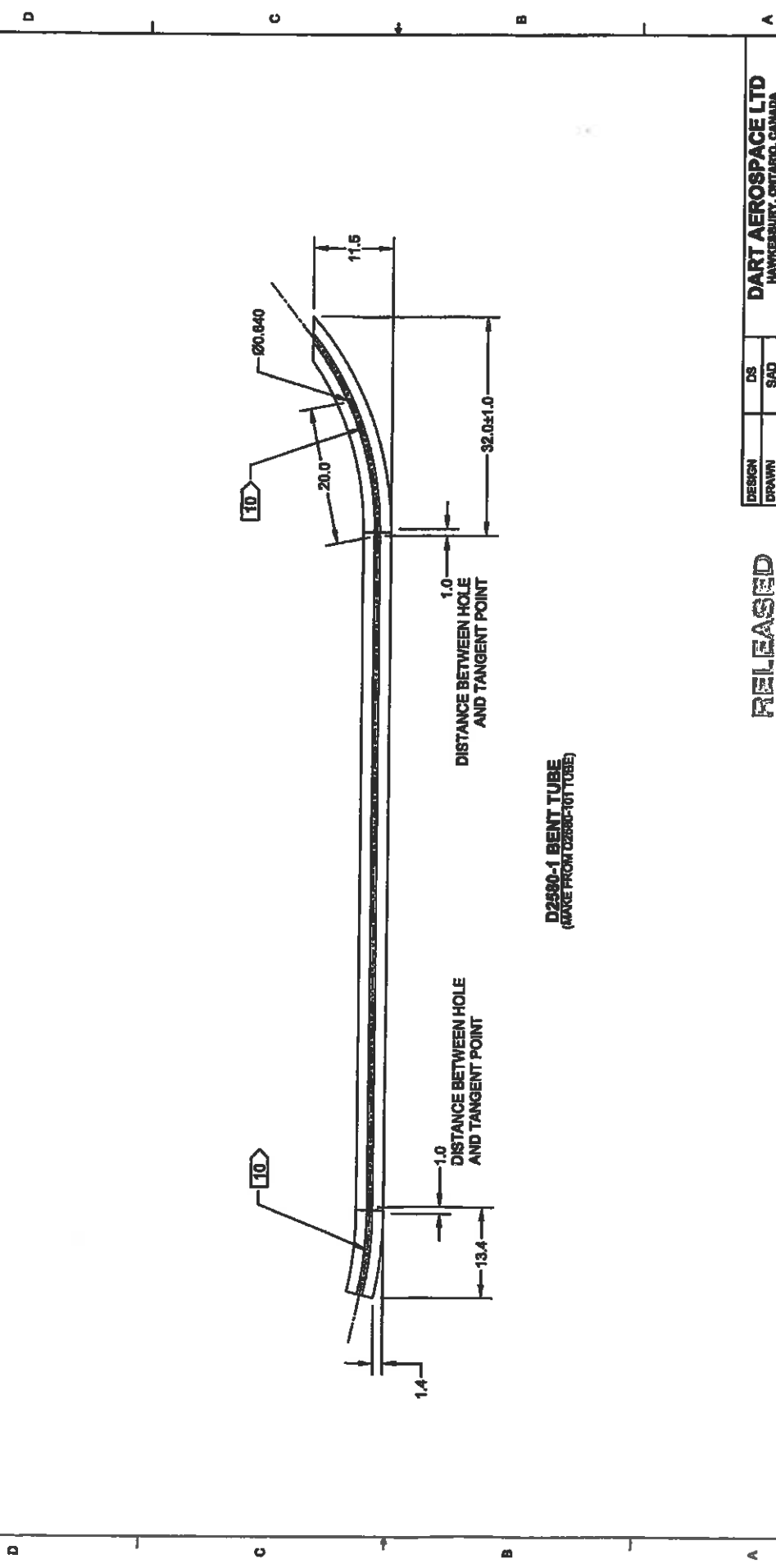


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DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2580
MFG. APPR.		REV. H SHEET 2 OF 9
APPROVED		TITLE 206 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE NTS

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1 2 3 4 5 6 7 8



D2590-1 BENT TUBE
(MAKE FROM D2590-101 TUBE)

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2017 JUL 05 q

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAO	HAWKESBURY, ONTARIO, CANADA
CHECKED	WJ	DRAWING NO.
INFO. APPR.	WJ	D2590
APPROVED	WJ	REV. H
DE APPR.	WJ	SHEET 3 OF 9
DATE	17.08.09	TITLE
		206 SKIDTUBE ASSEMBLY
		SCALE
		NTS

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**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.808 HOLES ONLY:**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2570 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CURE

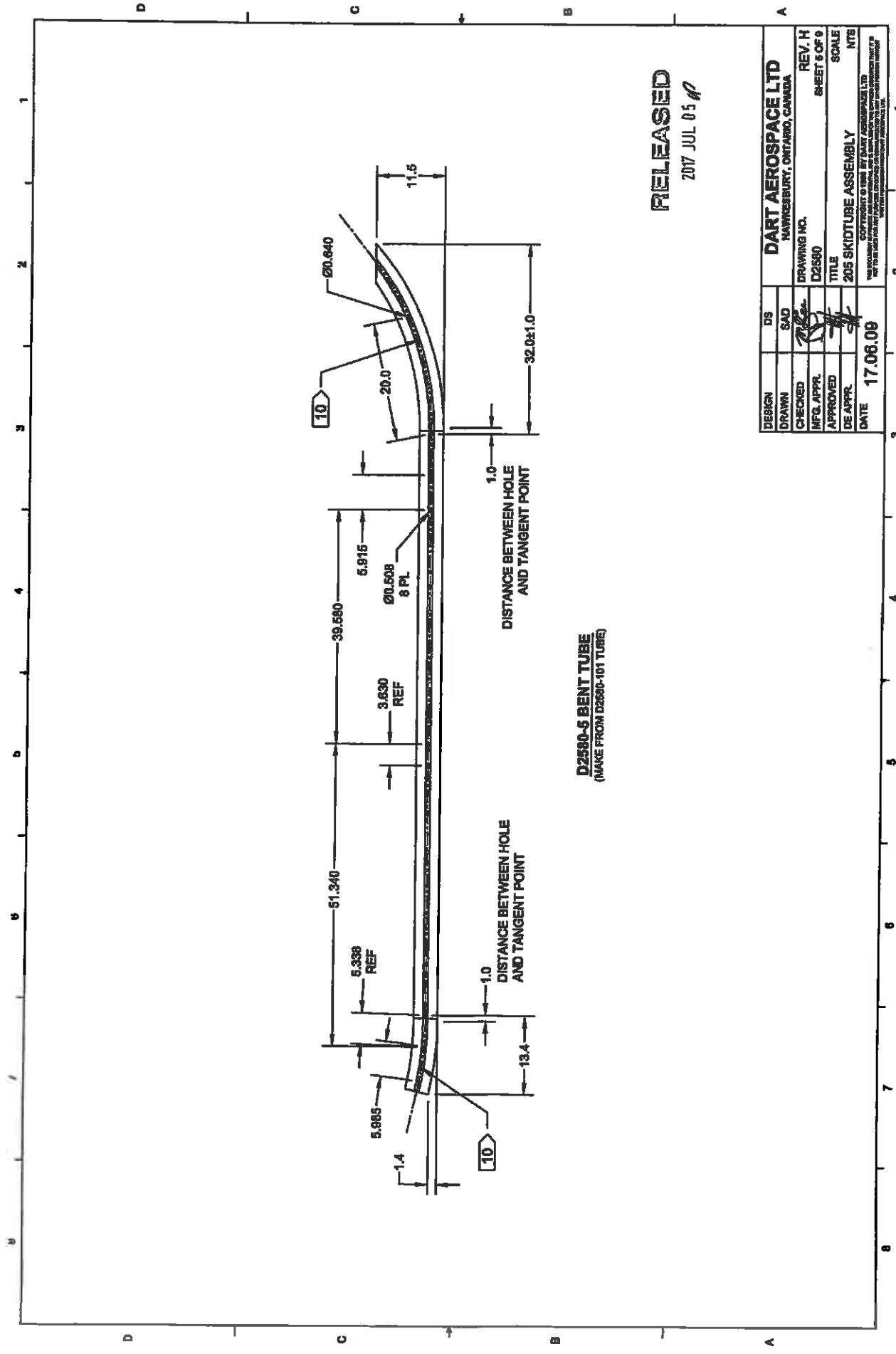
**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER Q61 002
3. TRAMGRIND FLUSH PER Q61 002

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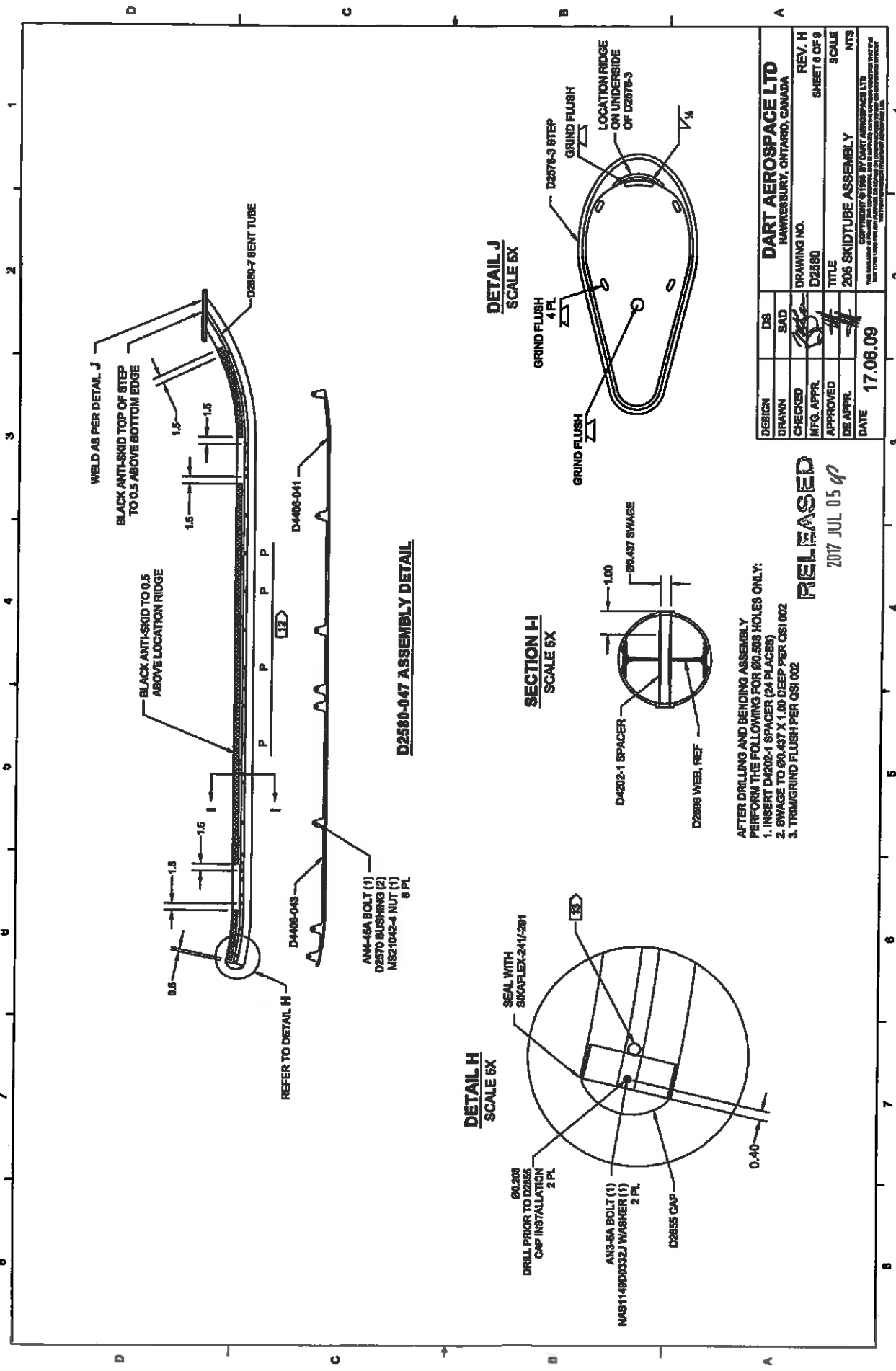
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 4 OF 9 SCALE NTS TITLE 500 SKIDTUBE ASSEMBLY COPYRIGHT © 2006 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.
DRAWN	SAD	
CHECKED		
MAFG. APPR.		
APPROVED		
DATE	17.06.09	DOE APPR.



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2017 JUL 05 #

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DRAWN	SAC	HAINSBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFQ APPR.		D2580
APPROVED		TITLE
DE APPR.		205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE
		NTS

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AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER CSI 002
3. TRIM/GRIND FLUSH PER CSI 002

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2017 JUL 05 02

DESIGN	D8	DART AEROSPACE LTD
DRAWN	SAD	HAWTHORNE, ONTARIO, CANADA
CHECKED		REV. H
INFO. APPR.	D2580	DRAWING NO.
APPROVED		SHEET 8 OF 9
DE APPR.		TITLE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY
		SCALE
		NTS

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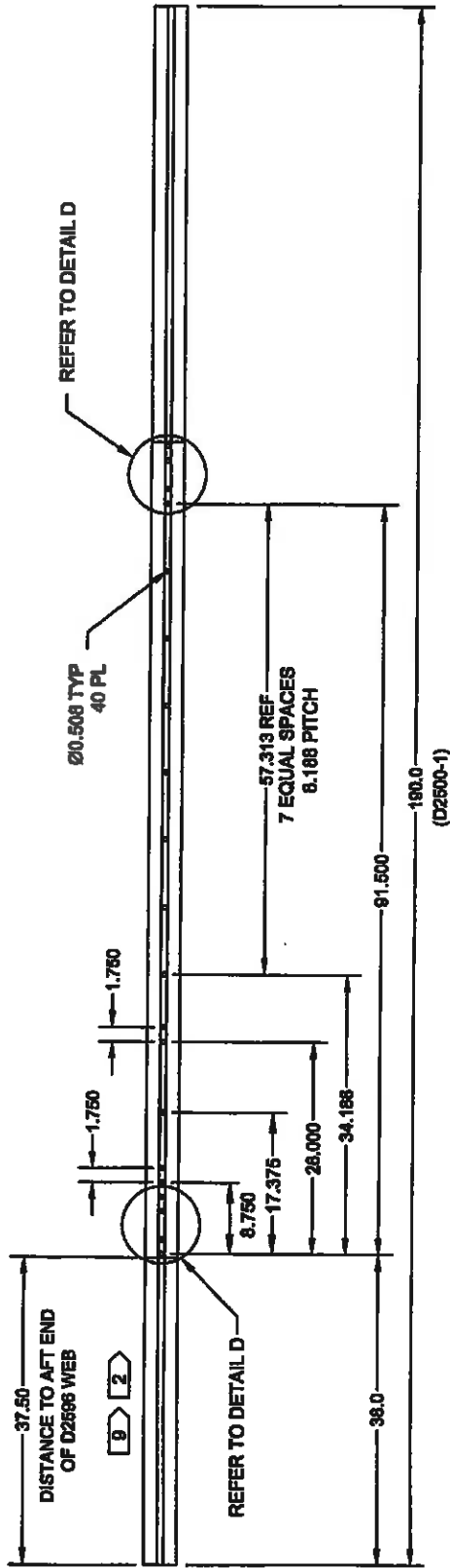




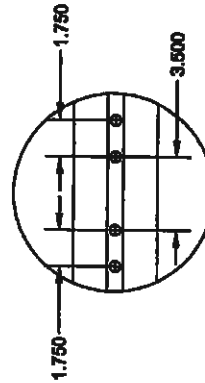
DESS RELEASE

2017 JUL 05 42

[illegible]



D2580-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

DESIGN	DS	SAO	DART AEROSPACE LTD HAWTHORNE, ONTARIO, CANADA
DRAWN	SAO	SAO	DART AEROSPACE LTD
CHECKED	SAO	SAO	DART AEROSPACE LTD
MFG. APPR.	SAO	SAO	DART AEROSPACE LTD
APPROVED	SAO	SAO	DART AEROSPACE LTD
DE APPR.	SAO	SAO	DART AEROSPACE LTD
DATE	17.06.09		
DRAWING NO. D2580 REV. H SHEET 9 OF 9 TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS COPYRIGHT © 1983 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED ONLY FOR THE PURPOSES SPECIFIED HEREIN.			



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No: _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)							
Description Work Order Deviation				Disposition							

Root Cause		FAULT CATEGORY											
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐									
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐									
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐									
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐									
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐									
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐									
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐										
Human Factors ☐	Other/Details: _____												

Completed By	Lead hand / Supervisor	QC / QA Coordinator
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